

Work Order ID 68652

Tuesday, April 19, 2011 2:20:25 PM



Page 1

Item ID:	D3391-015	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Aft Tube Assembly					
Start Date:	4/19/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/6/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-04-19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	Rev H

100		0.00							
	MORI SEIKI CNC LATHE LARGE								
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	Turn as per Folio FA599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>14</u>								

20 11.4.29 /

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

20 11.4.29 /

120		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA 599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>14</u> 2-Deburr								

20 11.5.4 /

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name:	Aft Tube Assembly			Stop		
Start Date:	4/19/2011	Start Qty:	1.00			
Required Date:	5/6/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo	0.00		29 11-5-4		1			
140 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00		SL 11/05/05					
150 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								

11-5-5

W/O:		WORK ORDER CHANGES						
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Item ID: D3391-015

Accept



Setup Start



Revision ID:

Stop



Item Name: After Tube Assembly

Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



CNC Bend 1

BENDING MACHINE - SKIDTUBES

0.00

CNC Delta 100 Bender

Memo

Form as per Dwg D3391

0.00

11-5-5

170



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

11-05-05

0

W/O:		WORK ORDER CHANGES						
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Revision ID:

Item Name: Aft Tube Assembly

Start Date: 4/19/2011 Start Qty: 1.00

Required Date: 5/6/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(All holes)

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297" and float bag holes to 0.328" as per
Dwg D3391.7- Tranfer holes from D3391-013 for electric step. Open holes as per dwg D3391-
section cc-cc

8-Deburr



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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

DP

11-5-5

200

Chemical Conversion Coat per QSI005 4.1

0.00



Hand Finish

Memo

0.00

Hand Finishing

SAD
11-05-05

①

205

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

B

11-05-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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[illegible]

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Stop

[illegible][illegible]

Customer:

Run -Start

[REDACTED]

Stop



Insp.
Stamp

0.00

[illegible]

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Install crossbolt spacers per dwg D3391.

A/R Magnabond 6398 batch:

1116678

08/2011

2- Grind flush

11.05.06

B 11.05.00

220

QC5- Inspect part completeness to step on W/O

0.00

[illegible]

QC

Memo

0.00

Quality Control

8/10/20

7

225

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043^M

IX ϕ m/l 11/05/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68652

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Item ID: D3391-015

Accept



Setup Start



Revision ID:

Item Name: Aft Tube Assembly

Stop



Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

250

HandFinishing

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts per dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291 M116945
Sikaflex expiry date: 12/07

(IX) 2:45 320 0.00
M-11/05/09

1 0 41 11/05/10

1 0 41 11/05/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 68652

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Item ID: D3391-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S w/05/12

270



Packaging

Packaging

Identify as per dwg & Stock Location: w/0

0.00

Memo

0.00

D412-722-041 / ~~B6863~~
B68635

1 d 11 w/05/10

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/11
LME
11-05/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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[illegible]

Required Qty: 1.00

Comments:	IPP rev A	05.12.13	New issue	EC	
	IPP rev B	06.02.09	Dwg @ revD	EC	
	IPP rev C	07.03.13	dwg @revF	ec	
	IPP rev D	07.10.31	ecn 1053P	EC	
	IPP Rev:E	ECN 1056	07-11-13	DD	verified by: EC
	IPP Rev:F	08-09-10	revH as per dwg	DD	verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	1,950.000	14	14			PTO=>
													
Insert													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST281		1950							
					<u>117331</u>	1950							
ALS4-1032-225		Purchased	No			250	Each	1,113.000	12	12			
													
Insert													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP-B		40							
					110768	40							
				ST282		1073							
					<u>110768</u>	1073							
ALS4-428-165		Purchased	No			250	Each	61.0000	4	4			
													
Inserts													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP-B		61							
					<u>114172</u>	61							

W/O: 68652		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/05/10	250	Scrap & Replace AHS4-1032-130 inserts M117331		JH	10/05/10	(x21)		11/05/10

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Picklist Print

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Work Order ID: 68652

Parent Item: D3391-015

Parent Item Name: Aft Tube Assembly

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

250

Each

2,358.000

6

6



BOLT



yl 1105/10

Location

Loc Qty

Loc Code

ST350

2358

116924

358

117094

1000

117313

1000

x6

AN3C5A

Purchased

No

250

Each

1,043.000

4

4



Bolt



yl 1105/10

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1036

115422

52

116419

384

116549

100

117343

500

x4

AN960C10L

NAS1149C0332

Purchased

No

100

Each

0.0000

10

10



washer

D2646

Manufactured

No

250

Each

56.0000

1

1



Aft Cap



yl 117291 (x10) yl 1105/10

yl 1105/10

Location

Loc Qty

Loc Code

FP006

56

62678

56

x1

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Shop Packet Print

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W/O:		WORK ORDER CHANGES						
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Parent Item: D3391-015

Parent Item Name: Aft Tube Assembly

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-1



Wearpad

Manufactured No

250

Each

54.0000

1

1



28 11/05/10

Location

Loc Qty

Loc Code

FP017

54

136613 5

X1

63313

2

66935

52

D3537-7



Wearpad

Manufactured No

250

Each

12.0000

1

1



28 11/05/10

Location

Loc Qty

Loc Code

FP017

12

56831

5

X1

65146

7

D3553-1



Gasket

Manufactured No

250

Each

24.0000

1

1



28 11/05/10

Location

Loc Qty

Loc Code

FP013

24

56568

24

X1

D3553-3



Gasket

Manufactured No

250

Each

48.0000

1

1



28 11/05/10

Location

Loc Qty

Loc Code

FP

20

31631

20

FP013

28

53480

28

X1

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Shop Packet Print

Page 3

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 19, 2011 2:20:21 PM

Page 4

Work Order ID: 68652

Parent Item: D3391-015

Parent Item Name: Aft Tube Assembly

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

250

Each

100.0000

14

14



SPACER

Location

Loc Qty

Loc Code

LG

100

67777

39

68107

61

D3672-1

Manufactured No

250

Each

1,387.000

2

2



Phenolic Washer

Location

Loc Qty

Loc Code

FP-A

37

52505

37

ST074

1350

64177

850

66821

500

D6014-090

Manufactured No

210

Each

14.0000

1

1



ALUMINUM EXTRUSION

Location

Loc Qty

Loc Code

LG

14

56572

14

11-05-06

11-05-10

x2

11-4-29

1

Tuesday, April 19, 2011 2:20:21 PM

Shop Packet Print

Page 4

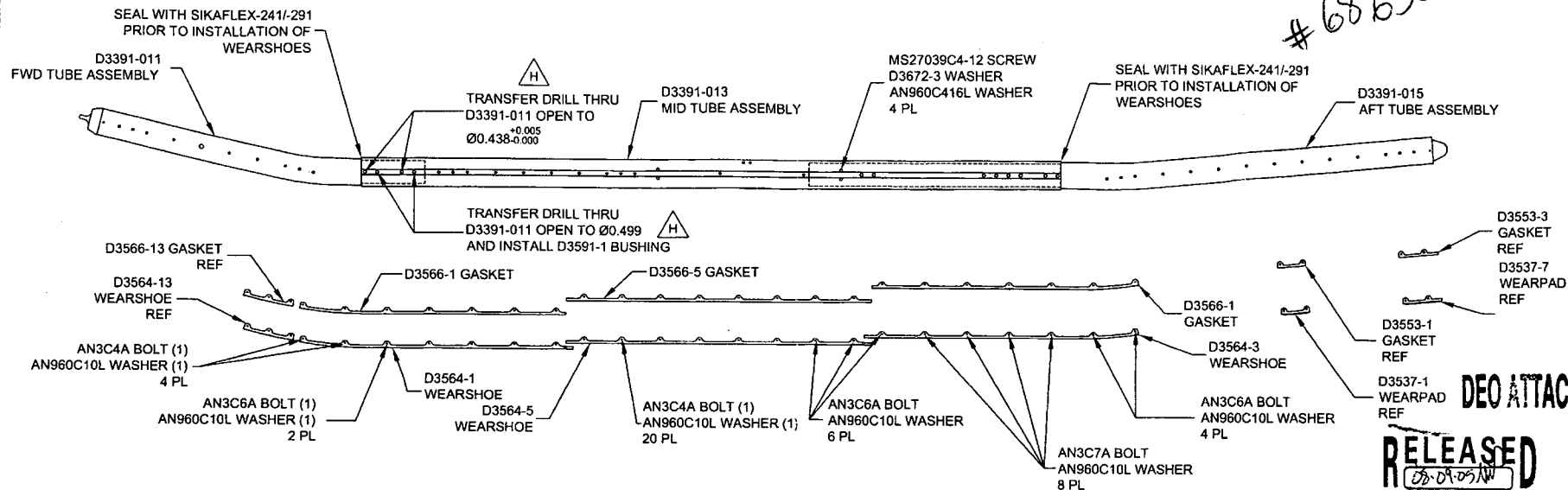
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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	Float Skidtube Assembly
1	D3391-011	FWD Tube Assembly
1	D3391-013	MID Tube Assembly
1	D3391-015	AFT Tube Assembly
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
1	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

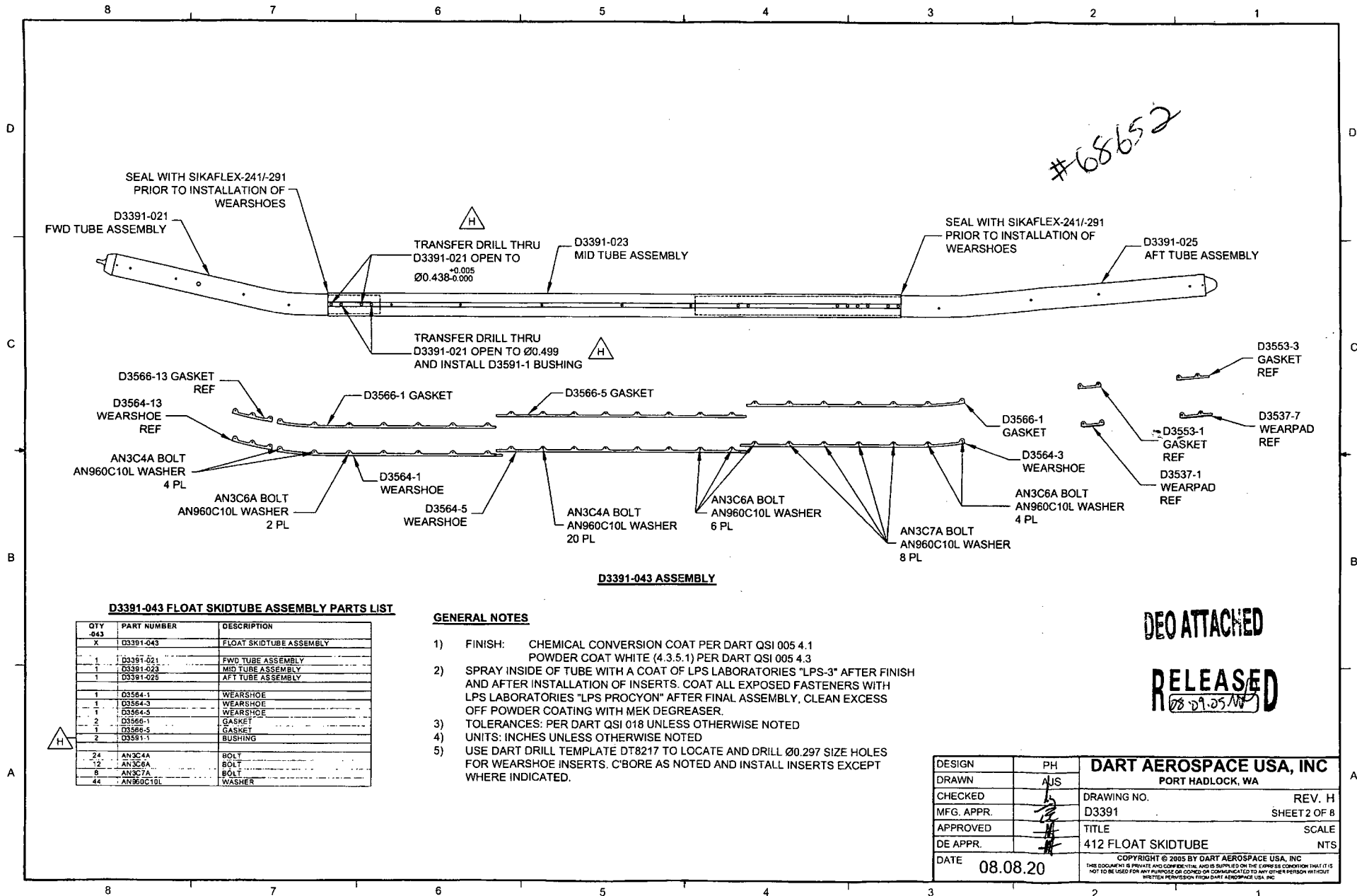
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

#68652



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	Float Skidtube Assembly
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED

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CHECKED			DRAWING NO.	REV. H
MFG. APPR.			D3391	SHEET 2 OF 8
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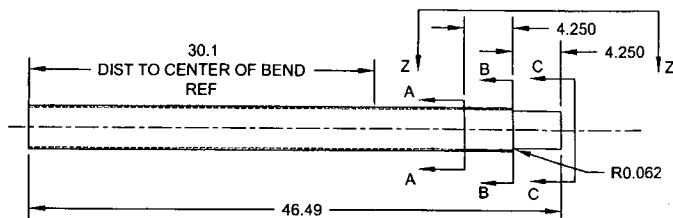
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

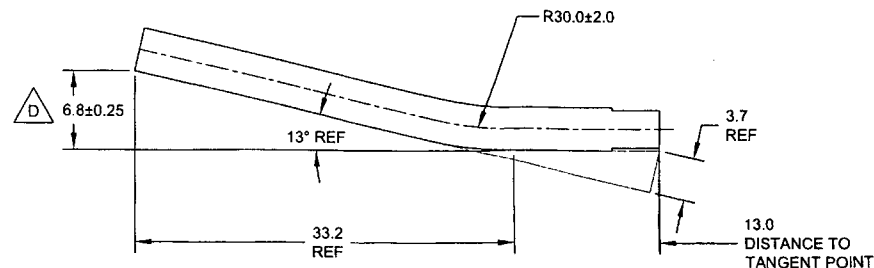
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			Initial Chief Eng	Action Description Chief Eng				

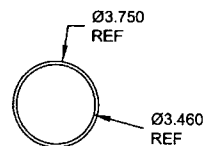
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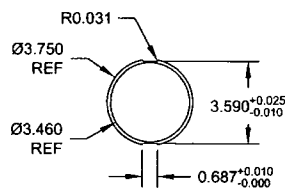
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



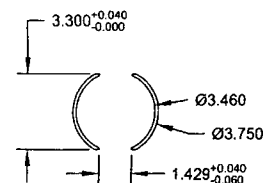
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



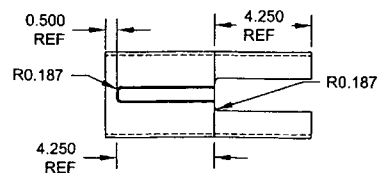
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

#68652

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28 JAN 05 NW

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MFG. APPR.			SHEET 3 OF 8
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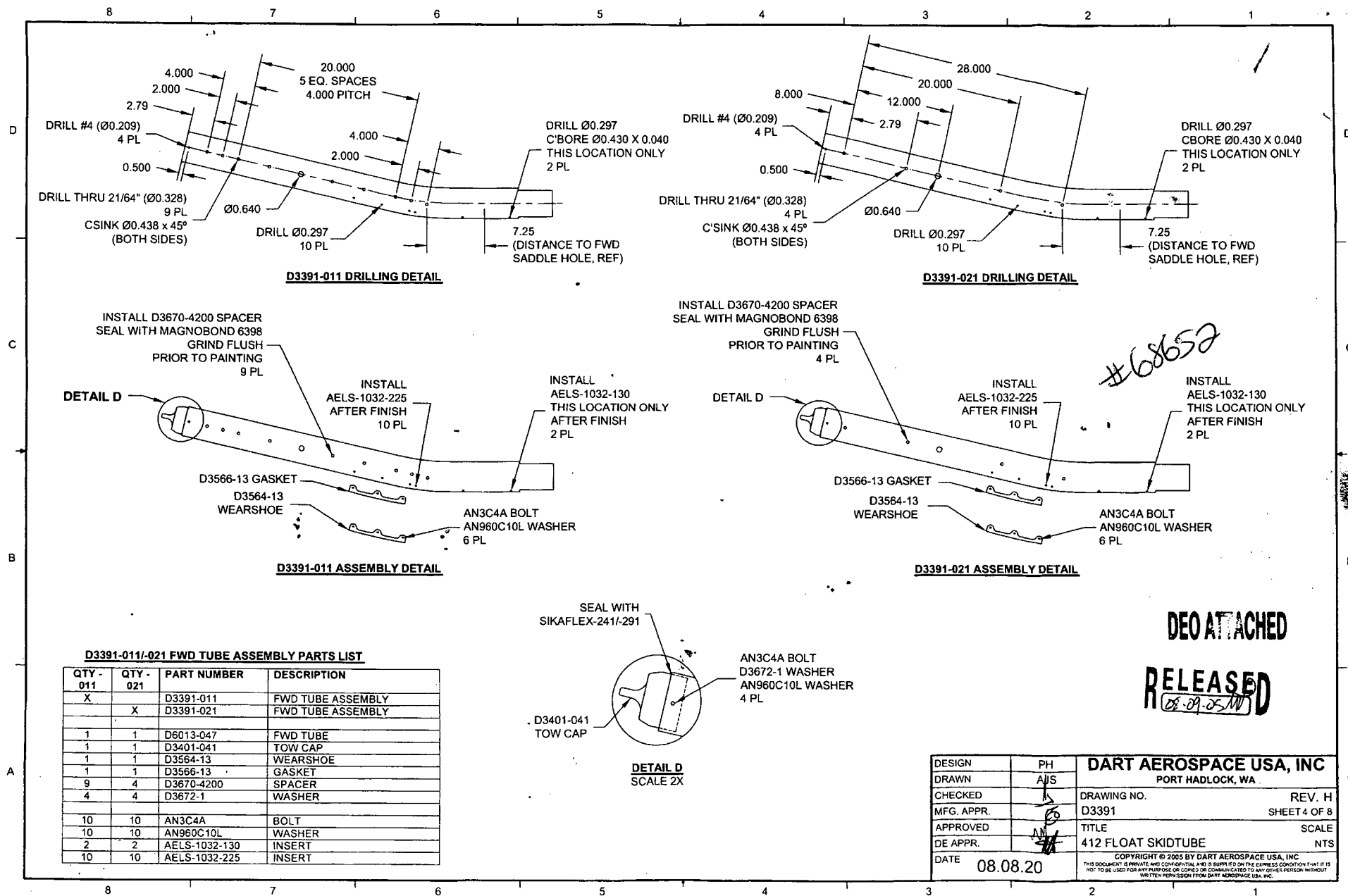
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



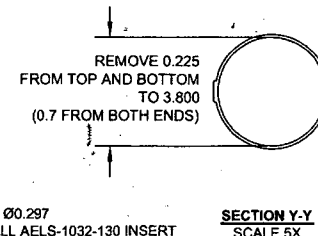
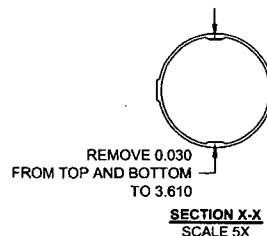
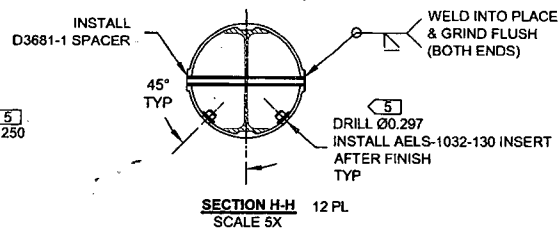
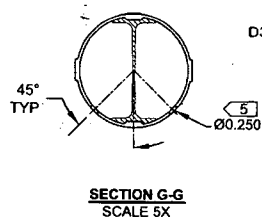
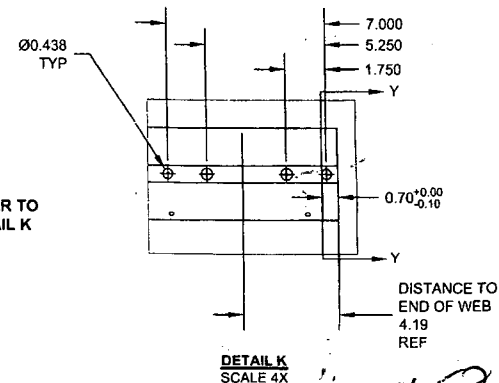
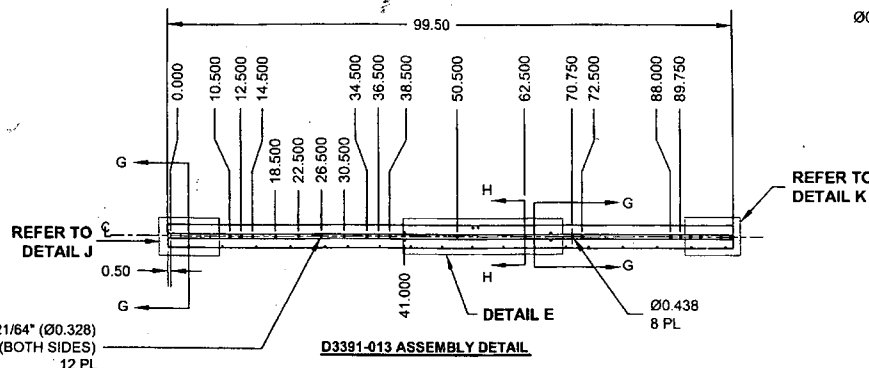
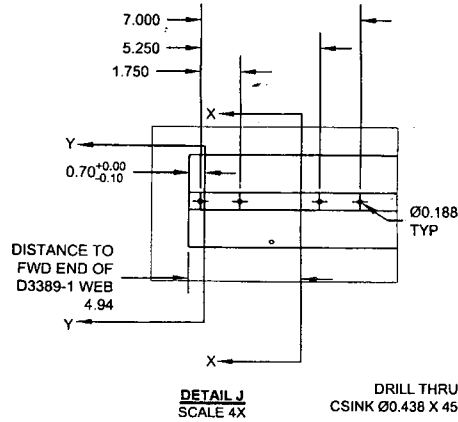
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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

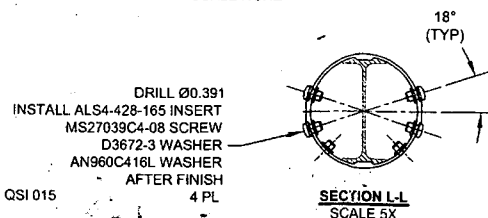
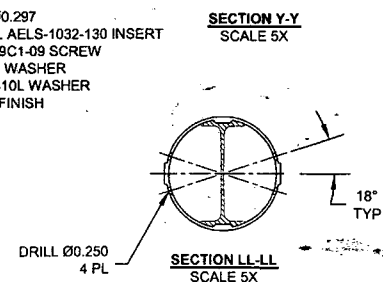
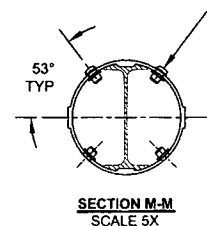
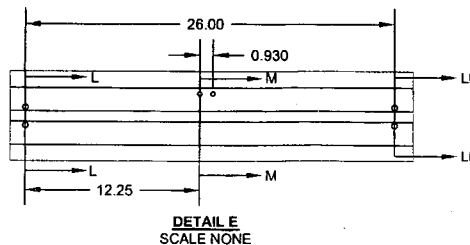
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ALIS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
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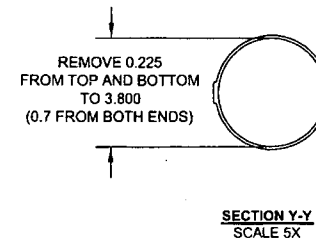
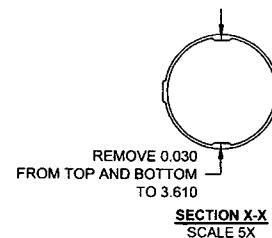
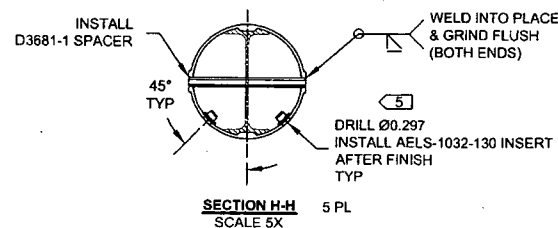
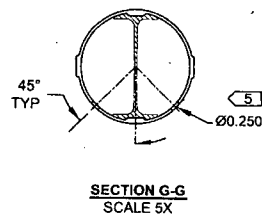
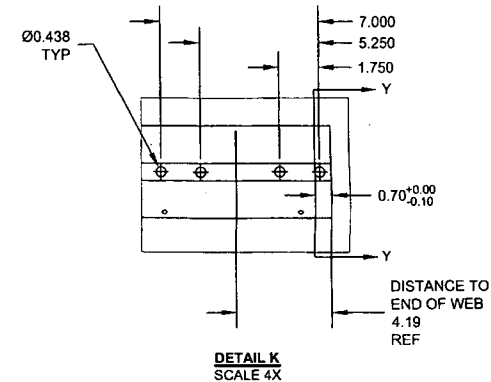
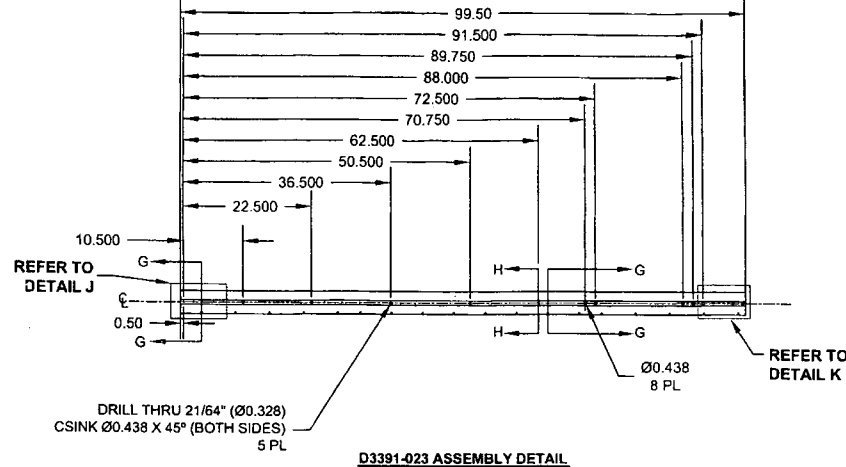
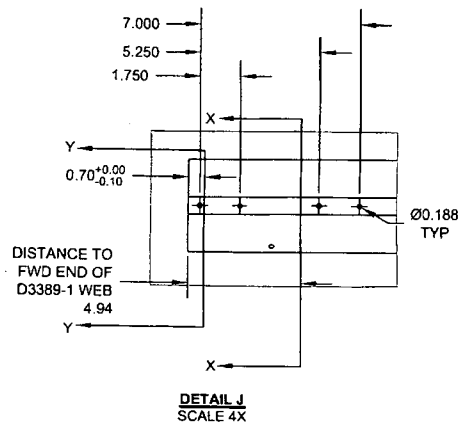
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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 6 OF 8
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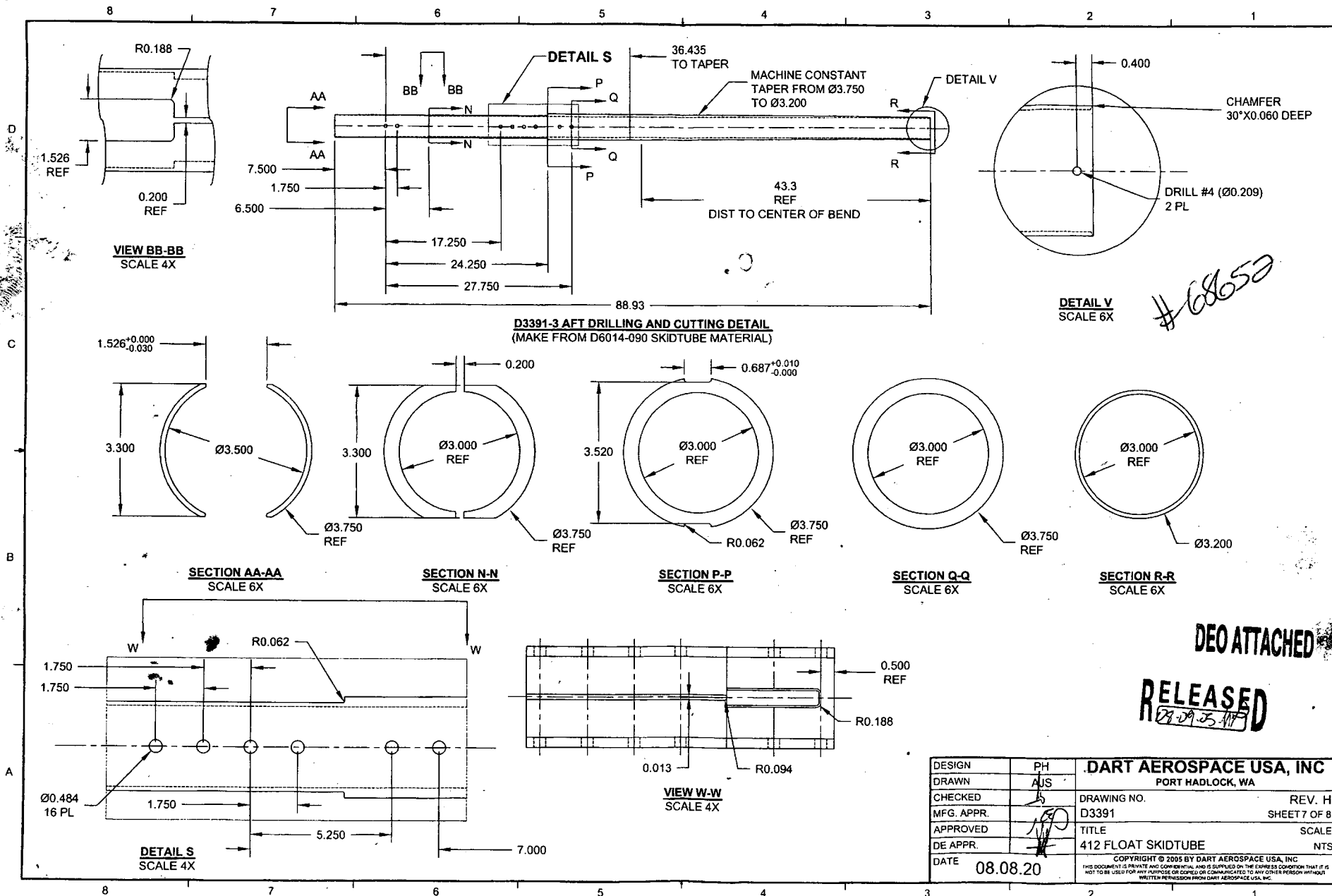
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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



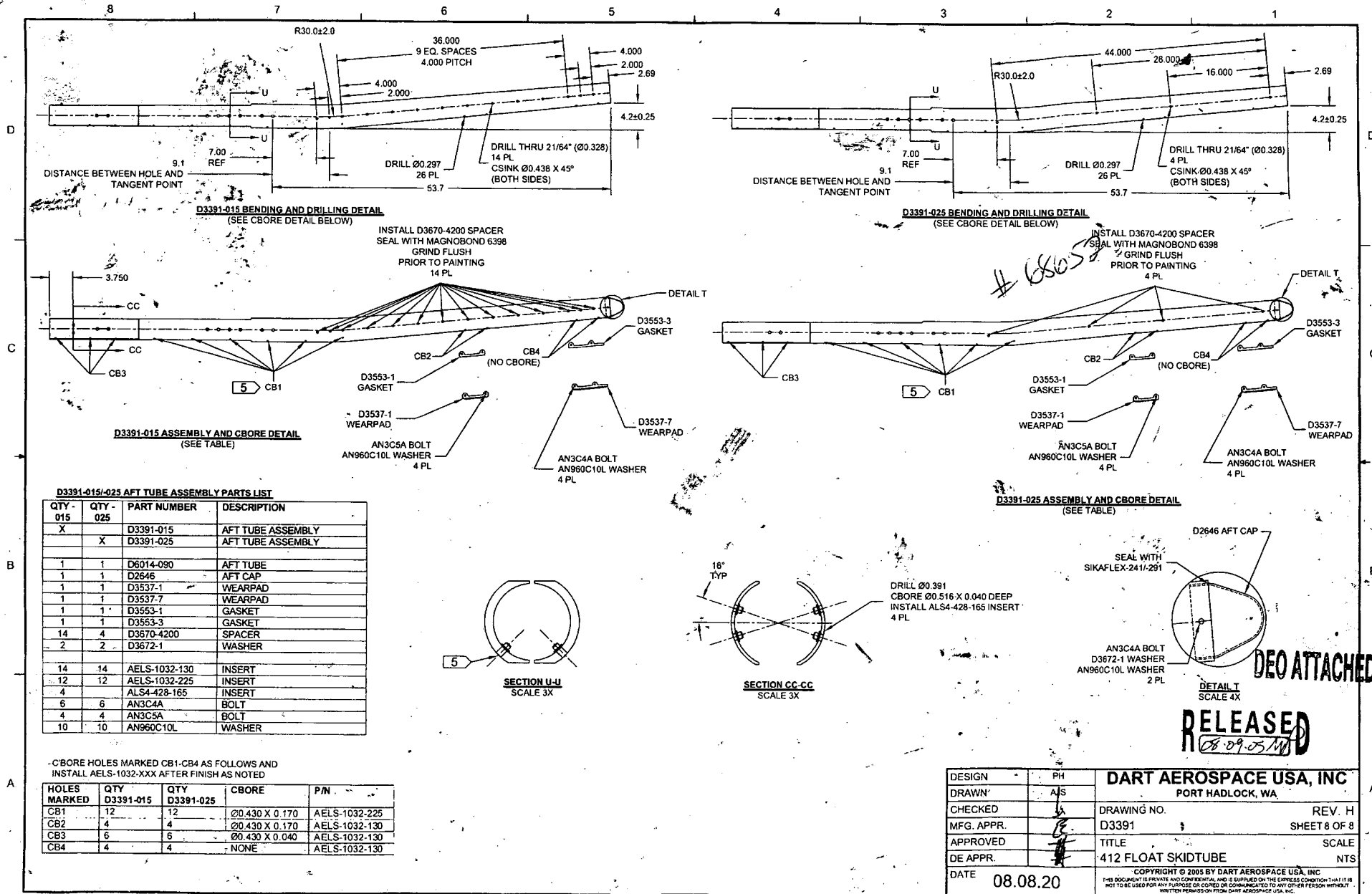
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



-CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 8 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP
#68652

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.600	/			
3.500	+/-0.010	3.497	/			
88.93	+/-0.030	88.937	/			
44.995	+/-0.030	44.250	/			STK MAT'L
Ø3.200	+/-0.010	3.200	/			
88.93	+/-0.030	88.937	/			
Ø3.750	+/-0.010	3.746	/			
30° x .160" chamfer	+/-0.010	30° x .160	/			

Measured by: _____

Date: _____

Audited by: _____

Date: _____

HAAS Section						
1.526	+0.000/-0.030	1.509	/			
7.500	+/-0.010	7.497	/			
27.750	+/-0.010	27.750	/			
31.750	+/-0.010	31.750	/			
35.250	+/-0.010	35.250	/			
3.300	+/-0.010	3.305	/			
0.200	+/-0.010	.198	/			
3.520	+/-0.010	3.526	/			
0.687	+0.010/-0.000	.687	/	X		
R0.062	+/-0.010	R0.062	/			
Ø0.484	+0.005/-0.001	.487	/			

Measured by: RD 11.5.4

Date: 11.5.4

Audited by: J. 11.5.4

Date: _____

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	

